

Date: Monday, 02/03/2009 10:10:08 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 02.250 SUPPORT		
Job Number	: 46159			Part Number	: D28911		
Estimate Number	: 11057			Drawing Number	: D2891 REV A1		
P.O. Number	:			Project Number	: N/A		
This Issue	: 02/03/2009	S.O. No.	:	Drawing Revision	: A1		
Prsht Rev.	: NC			Material	:		
First Issue	: //	Type	: PURCHASED PARTS	Due Date	: 02/04/2009		
Previous Run	: 45934			Qty:	20 Um: Each		
Written By	:						
Checked & Approved By	:						
Comment	: Est. C 02.11.26 Added P/O KJ Est. D 08.03.19 Re-format EC verified: DD						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DSK076	D2891-1 TURNING DETAIL	
		Comment: Qty.: 0.5000 Each(s)/Unit Total: 10.0000 Each(s) D2891-1 TURNING DETAIL B 4384 Batch: B44410X8	JL 09/03/18
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS Machine as per Folio FA046 Tumble & Deburr	JL 09/03/18
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	JL 09/03/18
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	8P 09/03/18
5.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3	
	START TIME:	8:45	(x20)
	OVEN TEMPERATURE:	400°	
	FINISH TIME:	9:15	cmo/Fd 09/03/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 10:10:08 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.250 SUPPORT

Job Number: 46159

Part Number: D28911

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(25)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-03-24

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CrossTube Assy (I&W)

AS 09-03-24 (20)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/25 (20)

Job Completion



MF  
09-03-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	46059
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891	Rev: A1		Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article  Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
<b>HAAS Section</b>								
AA	0.188	0.193		.189	.189	.189	.189	.189
AB	0.240	0.260		.251	.251	.252	.249	.250
AC	0.115	0.150		.127	.127	.127	.126	.125
AD	0.040	0.060		.052	.051	.050	.050	.050
AE	0.010	0.020		.015	.015	.015	.015	.015
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.295	.295	.295	.295	.295
AH	0.115	0.150		.138	.139	.138	.138	.138
AI	0.454	0.474		.463	.463	.464	.464	.454
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.037	1.024	1.034	1.032	1.035
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.258	.258	.258	.258	.258
AO	1.663	1.683		1.676	1.676	1.676	1.676	1.668
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
<b>Accept/Reject</b>								

Measured by: JL Date: 09/03/18

Audited by: SS Date: 09/03/23

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	SPJ

DART AEROSPACE LTD		Work Order:	46159
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891		Rev: A1	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article  Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	10
<b>HAAS Section</b>								
AA	0.188	0.193		.189	.189	.189	.189	.189
AB	0.240	0.260		.251	.251	.252	.250	.251
AC	0.115	0.150		.126	.125	.127	.127	.126
AD	0.040	0.060		.051	.051	.051	.053	.052
AE	0.010	0.020		.015	.015	.015	.012	.012
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.295	.295	.295	.297	.300
AH	0.115	0.150		.138	.138	.138	.140	.140
AI	0.454	0.474		.454	.464	.464	.463	.463
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.034	1.031	1.035	1.042	1.040
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.258	.258	.258	.258	.258
AO	1.663	1.683		1.668	1.677	1.677	1.678	1.677
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
<b>Accept/Reject</b>								

Measured by: JL / mm Date: 09/03/23

Audited by: SP Date: 09/03/23

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	SP

DART AEROSPACE LTD		Work Order:	410159
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891	Rev: A1		Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article  Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
HAAS Section								
AA	0.188	0.193		.190	.190	.190	.190	.190
AB	0.240	0.260		.247	.246	.252	.251	.249
AC	0.115	0.150		.127	.125	.125	.133	.129
AD	0.040	0.060		.053	.050	.053	.054	.055
AE	0.010	0.020		.015	.015	.015	.013	.015
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.291	.295	.291	.300	.291
AH	0.115	0.150		.140	.138	.138	.145	.135
AI	0.454	0.474		.456	.456	.454	.454	.463
AJ	2.779	2.789		2.783	2.783	2.783	2.783	2.783
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.038	1.042	1.034	1.040	1.038
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.259	.259	.259	.260	.260
AO	1.663	1.683		1.671	1.672	1.667	1.666	1.676
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.033	.032
AR								
AS								
AT								
Accept/Reject								

Measured by: mm Date: 09/03/23

Audited by: 88 Date: 09/03/23

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	9/03/23

DART AEROSPACE LTD		Work Order:	40159
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891 Rev: A1			Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article  Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions					
				1	2	3	4	5	
<b>HAAS Section</b>									
AA	0.188	0.193		.190	.190	.190	.190	.190	.190
AB	0.240	0.260		.249	.249	.250	.247	.249	
AC	0.115	0.150		.127	.125	.124	.125	.123	
AD	0.040	0.060		.053	.053	.053	.050	.050	
AE	0.010	0.020		.015	.015	.015	.015	.015	
AF	0.240	0.260		.250	.250	.250	.250	.250	
AG	0.290	0.310		.291	.300	.300	.306	.301	
AH	0.115	0.150		.135	.138	.136	.137	.138	
AI	0.454	0.474		.463	.462	.463	.466	.465	
AJ	2.779	2.789		2.783	2.782	2.783	2.784	2.784	
AK	0.240	0.260		.250	.250	.250	.250	.250	
AL	1.002	1.042		1.037	1.043	1.037	1.038	1.038	
AM	0.053	0.073		.063	.062	.063	.063	.063	
AN	0.257	0.262		.259	.259	.259	.259	.259	
AO	1.663	1.683		1.676	1.675	1.676	1.677	1.675	
AP	0.053	0.073		.063	.062	.063	.063	.063	
AQ	0.022	0.042		.032	.032	.032	.032	.032	
AR									
AS									
AT									
<b>Accept/Reject</b>									

Measured by: mmf Date: 09/03/19

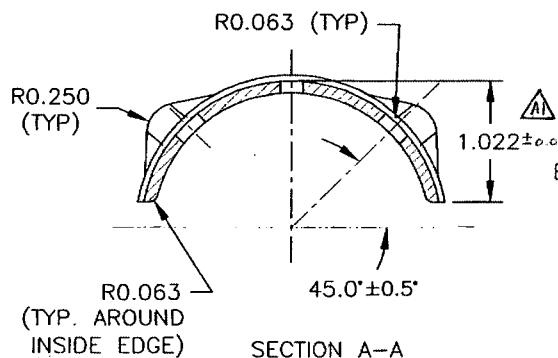
Audited by: 86 Date: 09/03/23

Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

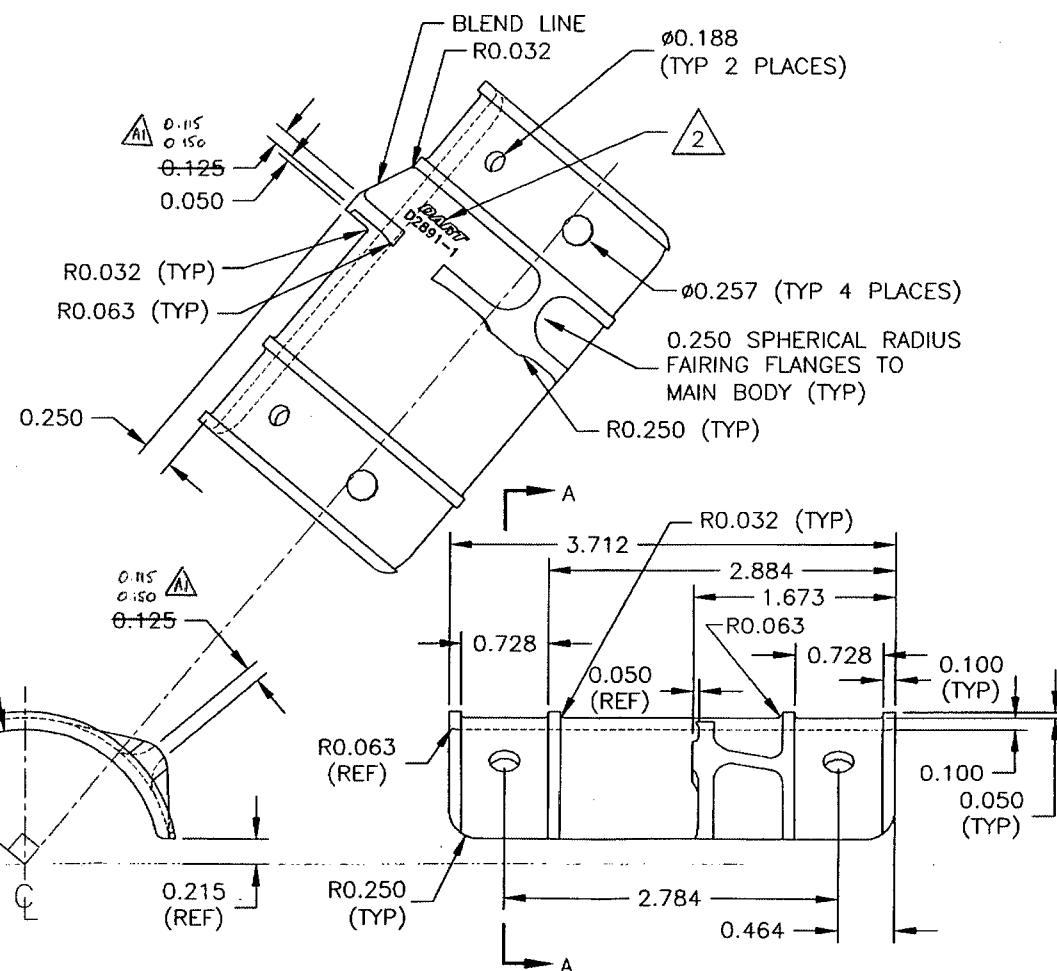
Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	<u>JL</u>
B	08.04.21	Reformat	KJ/JLM	<u>JL</u>

D2891-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP.
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF.  
 $X_{XXX} = \pm 0.010$ ) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



SECTION A-A  
NO. 4/6/5  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY



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AI	CP 02-01-23	UPDATE DMS AS MANUFACTURED
A	00.11.17	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	CP	APPROVED CP
DATE	00.11.17	TITLE Ø2.250 SUPPORT
		SCALE 1:1